

FRIDAY MORNING  
May 4th 12

Work Order ID 84137

Thursday, May 03, 2012 3:01:15 PM

\*84137\*

Page 1

Item ID: D212-725-1-107f

Accept

\*N900040100\*

Setup

Start \*NS1\*

Revision ID:

Item Name: Angle

Stop

\*NS2\*

Start Date: 5/3/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *WF*

Date: 12-05-12 Cooling:

Date:

Run

Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D212-725-1

F

100

\*100\*

Waterjet

FLOW CNC Waterjet

2024 0040

Memo

1-Cut as per Dwg

Dwg Rev: *F*

Prog Rev: *F*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

① ②

JM/HM  
12-5-4

① ②

JM/HM  
12-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84137  
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Page 2

Item ID: D212-725-1-107f

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\*NS1\*

Revision ID:

Item Name: Angle

Stop

\*NS2\*

Start Date: 5/3/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00	5/26/04						

130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00							
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00							

*N* *A* *MF 12-05-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 84137  
Thursday, May 03, 2012 3:01:15 PM

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Page 3

Item ID: D212-725-1-107f

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\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Angle

Stop

\*NS2\*

Start Date: 5/3/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

1 2 29 12/05/04

Hand Finishing

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

mk  
12/05/04

Quality Control

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

\*170\*

Packaging

Memo

0.00

12/05/04

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84137

Thursday, May 03, 2012 3:01:15 PM

\*84137\*

Page 4

Item ID: D212-725-1-107f

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\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Angle

Stop

\*NS2\*

Start Date: 5/3/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

180

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

\*180\*

QC

Quality Control

Memo

0.00

ML12/05/04  
MF  
12/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, May 03, 2012 3:01:14 PM

Page 1

Work Order ID: 84137

Parent Item: D212-725-1-107f

Start Date: 5/3/2012

Required Date: 5/3/2012

Parent Item Name: Angle

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	214.9312	0.09148	0.0962947			

Location	Loc Qty	Loc Code
MAT022	214.9311626	
117684	21.318421	
120196	37.35	
120605	64.7627416	
121197	91.5	

121197  
10.1

Jay/NH  
12-5-14

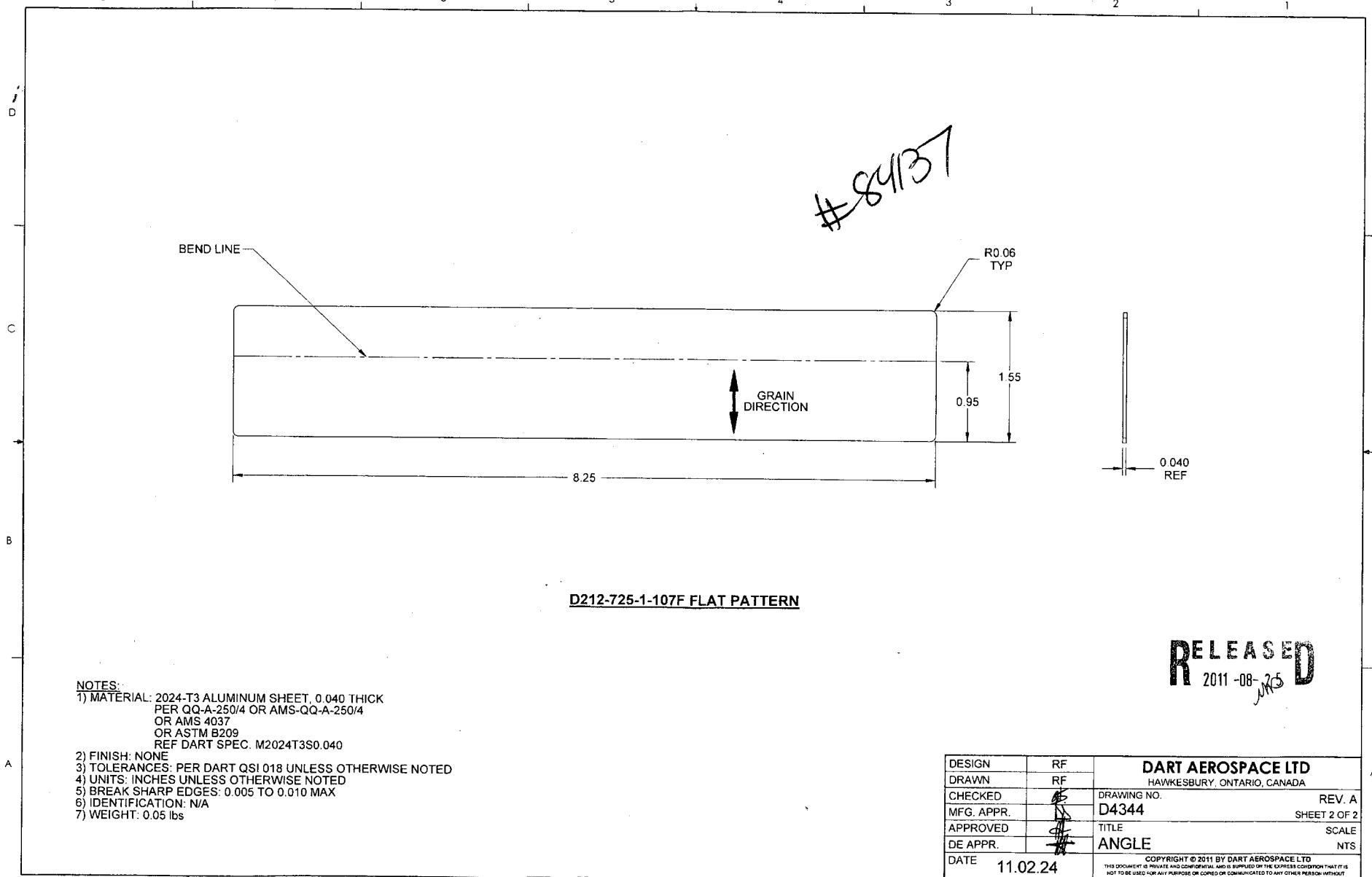
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD	Work Order:	811-37
Description: Angle	Part Number:	D212-725-1-107F
Inspection Dwg: D212-725-1 Pg 32 of 84	Rev: F	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>Jm/sat</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>12-5-4</u>	Date: <u>12/05/4</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.11.15	New Issue	KJ	9/1